

Date: Thursday, 04/12/2008 9:10:55 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WINDOW		
Job Number	: 43903			Part Number	: D32903		
Estimate Number	: 11176			Drawing Number	: D3290 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 04/12/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 20/12/2008		
Previous Run	: 42413			Qty:	10	Um:	Each
Written By	:						
Checked & Approved By	<u>JUL 08 12 04</u>						
Comment	Est. A 04.08.18 New issue KJ/RF Est. B 06.05.09 Ecn 798 EC Est. C 07.05.29 Thermoform in-house DL Est. D 07.09.28 rev C dwg EC verified by: DD Est. E 07.11.28 Add -Hand finish deburring DL						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	MACRLICS125	1/8" Polycast II Sheet 38
Comment: Qty.: 3.1500 sf(s)/Unit Total : 31.5000 sf(s) $109510 \times 3 = 9.45$ Polycast II or plexiglass G .125" $110115 \times 9 = 98.35$		
2.0	WATER JET	FLOW WATER JET 13 8-12-16
Comment: FLOW WATER JET 1-Cut as per Dwg D3290 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 12		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE HR 8-12-16
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK S GS 12/16 X12
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Without removing protective skin
remove sharp edge by degurring.

BB 08/12/16 X 12

6.0 THERMOFORMING

THERMOFORMING MACHINE



Comment: 1-THERMOFORM as per Drawing D3290 and Folio FTA001

Dwg. Rev. C
Folio Rev. B

2-Engrave part# & batch#,
(D3290-3)

BB 08/12/16 X 12

7.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformances

BB . 08/12/16 X 12

8.0 QC8

SECOND CHECK



Comment: SECOND CHECK

S 08/12/17 X 12

9.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches if required

BB 08/12/17

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/17 X 12

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

ST216

L 08/12/17 X 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes, No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/19 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43903
Description: Window	Part Number:	D3290-3
Inspection Dwg: D3290 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	08-12-16	Date:	08/17/16	Date:	N/A

Rev	Date	Change	Revised by,	Approved
A	08.01.16	New Issue	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

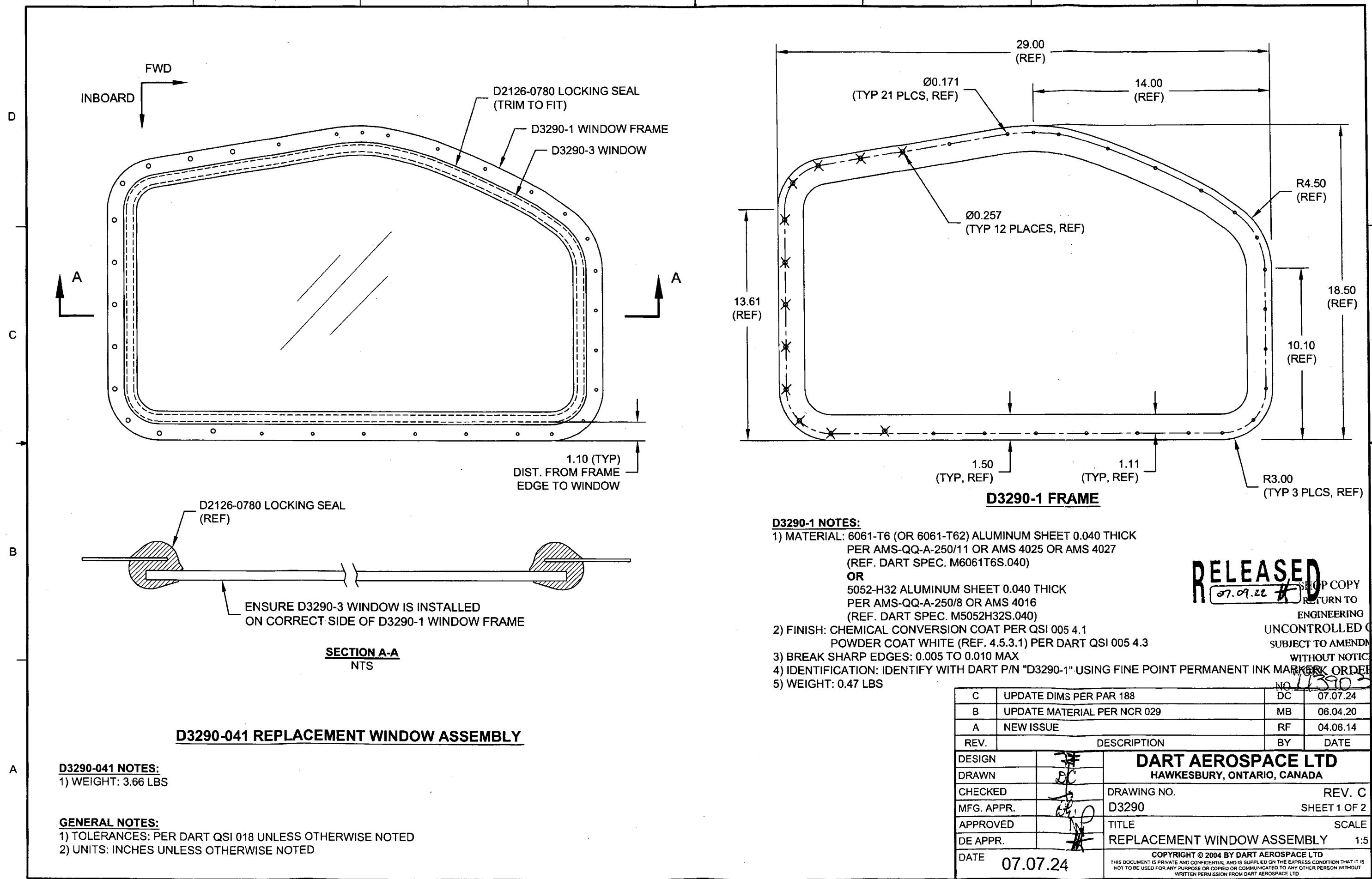
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

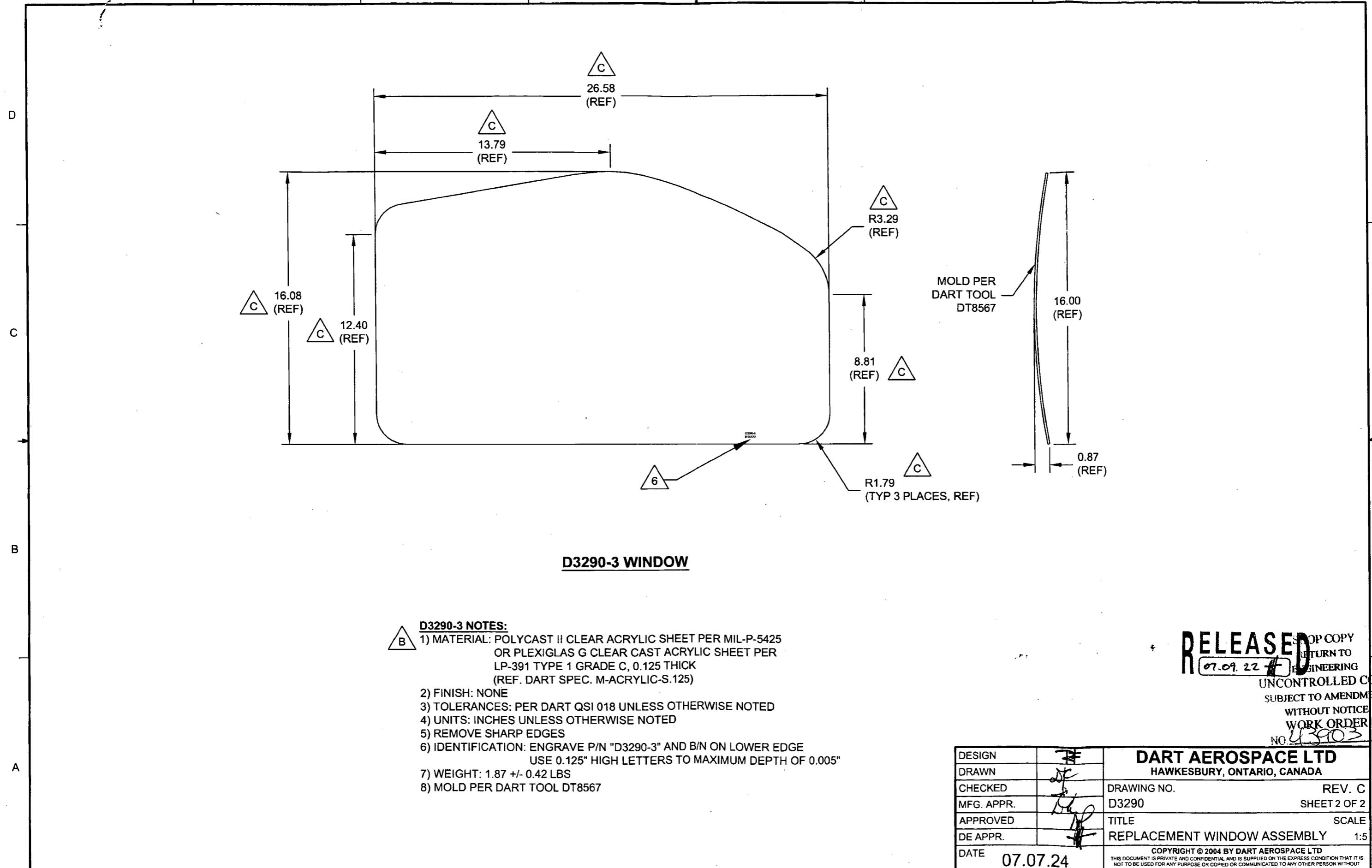
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1